



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3314

Job Sheet 171982



Part No: 646.3314

Job Qty: 16 ea

Part Name: Blade



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/9/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 2/28/18

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12/11/07 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea	2/27/18	2/27/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	16 pcs	2/27/18	2/27/18	0.00	0.62	Bandsaw1		
110	CNC Vertical Machining	16 pcs	2/27/18	2/27/18	0.14	15.38	HAAS1-1		
120	QC	16 pcs	2/27/18	2/27/18	0.00	0.00	QC2 Machining-1		
130	QC	16 pcs	2/27/18	2/27/18	0.00	0.00	QC8 Machining-1		
140	Outsource	16 pcs	2/27/18	2/27/18			MEI001-VCRO39483		
150	Packaging	16 pcs	2/27/18	2/27/18	0.00	0.00	Packaging2		
155	QC	16 pcs	2/27/18	2/27/18	0.00	0.00	QC5		
160	SprayPaint	16 pcs	2/28/18	2/28/18	0.00	0.49	Spray Paint		
170	QC	16 pcs	2/28/18	2/28/18	0.00	0.00	QC14		
180	Packaging	16 pcs	2/28/18	2/28/18	0.00	0.00	Packaging3-1		
190	QC21-SA	16 Ea	2/28/18	2/28/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 5.050"

Descriptions: 110 - 1-Machine per folio FB147

140 - HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL

160 - PRIME AS PER DWG, SEE NOTE #4 138747

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	6.7360 ft (.421 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MSTEEL-A2-B0.500X1.250	7	69	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 832-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S052415



Part: 646.3314

Job No: 171982

Serial No/Batch: S052415

Revision:

Inspector:

Date: 03/17/10

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	4.900inches $\pm$ 0.010	4.910 4.890		
2	Blade	4.257inches $\pm$ 0.005	4.262 4.252		
3	Blade	0.177inches $\pm$ 0.005 - 0.001	0.182 0.176	Diameter	
4	Blade	0.940inches $\pm$ 0.010	0.950 0.930		
5	Blade	0.375inches $\pm$ 0.005	0.380 0.370		
6	Blade	0.325inches $\pm$ 0.005	0.330 0.320		
7	Blade	30.000Degrees $\pm$ 0.500	30.500 29.500	Angle	
8	Blade	0.524inches $\pm$ 0.005	0.529 0.519		
9	Blade	0.524inches $\pm$ 0.005	0.529 0.519		
10	Blade	0.240inches $\pm$ 0.002	0.242 0.238		
11	Blade	0.666inches $\pm$ 0.002	0.668 0.664		
12	Blade	1.109inches $\pm$ 0.002	1.111 1.107		

Plex 2/9/18 3:01 PM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039483

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039483
PO Date: 4/2/18
Due Date: 4/12/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174484	D5304-1	Crossbolt Spacer 1--Issue P/O to Metcore ; P/O HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL	Firmed	4/12/18	22 pcs	0 pcs	22 pcs	\$1.207052/pcs	\$26.56
2	174482	D4686-1	Spacer HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL	Firmed	4/12/18	25 pcs	0 pcs	25 pcs	\$1.207052/pcs	\$30.18
3	171982	646.3314	Blade HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL	Firmed	4/12/18	16 pcs	0 pcs	16 pcs	\$19.50/pcs	\$312.00

Plex 4/5/18 2:07 PM dart.tsimiklis.chrisoula

DA-
38
9-89

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
326645	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
39483	N/A	A2		
SPECIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC		5	59 - 61 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
16	6	646,3314 (16) 646.3314 JOB. 171982 1 BC EPS		

COMMENTAIRES / comments

VAC HARDEN 1800F, 1:30 HRS

DOUBLE TEMPER 450F, 3 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

This document and any attached documents may contain confidential or proprietary information and may be subject to export control laws and regulations. If you are not the intended recipient, you are notified that any dissemination, copying of this e-mail and any attachments thereto or use of their contents by any means whatsoever is strictly prohibited. Unauthorized export or re-export is prohibited.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée.

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

APPROUVÉ par / Approved by:

Isabel Otero

Isabel Otero

QA Technician



DATE: 2018-04-09

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
326645	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
39483	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	5	59 - 61 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
16	6	646,3314 (16) 646.3314 JOB. 171982 1 BC EPS

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2018-04-09

Pierre Piché
Chief Inspector



APPROUVÉ